

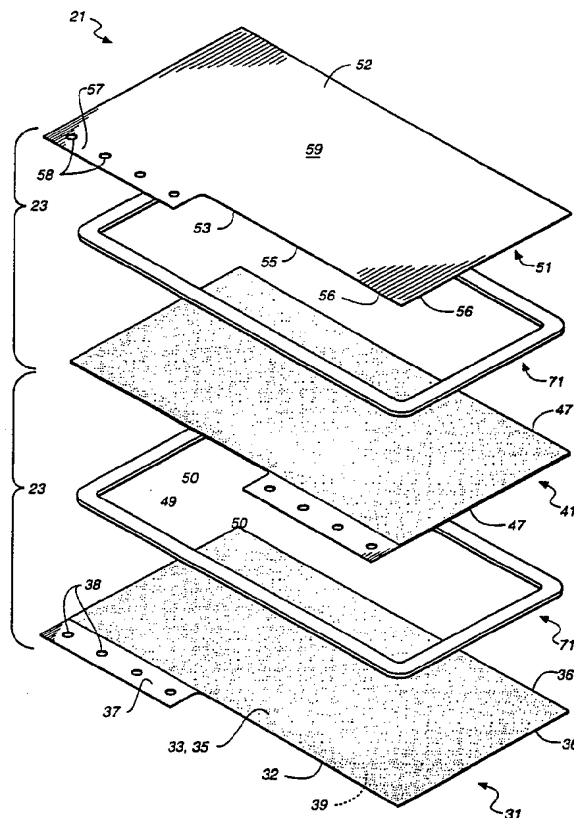


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(54) Title: BATTERY MODULE AND METHOD OF MAKING A BATTERY**(57) Abstract**

A battery module includes a number of electrically connected electrochemical cells. In a preferred embodiment, the battery includes multi-cell batteries in which electrodes are separated from different potential electrodes by a layer of polymer electrolyte. The battery module is formed from a number of multi-cell batteries stacked on top of one another, the electrodes of each multi-cell being electrically connected to one another, and the different potential electrodes of each multi-cell being electrically connected to one another so that a battery module having desired power characteristics is formed. The battery module includes electrically conductive spacers for electrically connecting tabs on the electrodes to tabs on other electrodes and tabs on the different potential electrodes to tabs on other different potential electrodes and for preventing damage to the tabs or the electrodes or different potential electrodes from bending the tabs excessively.



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**BATTERY MODULE AND METHOD
OF MAKING A BATTERY****BACKGROUND OF THE INVENTION****FIELD OF THE INVENTION**

5 The present invention relates to batteries and, more particularly, the present invention relates to batteries of the type having a polymer electrolyte.

STATE OF THE ART

10 In recent years, individuals in the battery art have begun to understand the advantages of manufacturing batteries that have polymer electrolytes and sheet-like cathodes and anodes. The advantages include lower battery weight than batteries that employ liquid electrolytes, longer service life, relatively
15 high power densities, relatively high specific energies, and the elimination of danger due to the spillage of acidic liquid electrolytes.

 In fabricating batteries, it is generally necessary to connect an anode to an anode current
20 collector and a cathode to a cathode current collector so that electric energy can be drawn from the battery by an external load. In multi-cell batteries, current collectors are generally connected to each anode and each cathode, and the current collectors connected to
25 each anode are electrically connected together and the current collectors connected to each cathode are electrically connected together.

 In batteries of the type that have a thin polymer electrolyte and sheet-like anode and cathode

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layers, it is common that a relatively large number of individual cells form a battery. The connection of separate current collectors to the individual anode and cathode layers of the cells can be quite troublesome.

5 One problem is that relatively large numbers of current collectors must be provided. Further, means for attaching the current collectors to the anodes and cathodes must be provided. Further still, as the anode and cathode layers are generally quite thin, the
10 current collectors and the means for attaching the current collectors must not be overly large or obtrusive such that they interfere with one another or with the formation of the battery.

SUMMARY OF THE INVENTION

15 The present invention, generally speaking, provides a battery that uses a polymer electrolyte in lieu of a liquid electrolyte to attain desired operating characteristics in a small, light-weight battery.

20 In accordance with one aspect of the present invention, an electrochemical cell includes a first electrode, a second electrode, and electrolyte material. The first electrode includes means for first electrode current collection, the first electrode
25 current collection means being formed from a first conductive sheet, and a layer of first electrode material. The second electrode is of a different potential than that of the first electrode and includes means for second electrode current collection, the
30 second electrode current collection means being formed from a second conductive sheet, and a layer of second electrode material. An electrolyte is coated on one of the first or second electrode materials and contacts

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with the other of the first or second electrode materials. An outer periphery of the first electrode is larger than an outer periphery of the second electrode such that substantially all of the outer
5 periphery of the second electrode is bounded by the outer periphery of the first electrode.

In accordance with another aspect of the present invention, a multi-cell battery module includes a first electrode, a second electrode, a third
10 electrode, and electrolyte material. The first electrode includes means for first electrode current collection, the first electrode current collection means being formed from a first conductive sheet, and a layer of first electrode material contacting a surface
15 of the first conductive sheet. The second electrode includes means for second electrode current collection, the second electrode current collection means being formed from a second conductive sheet, and first and second layers of second electrode material contacting
20 first and second surfaces of the second conductive sheet, the second electrode material is of a different potential than that of the first electrode material. The third electrode includes means for third electrode current collection, the third electrode current
25 collection means being formed from a third conductive sheet, and a layer of third electrode material contacting a surface of the third conductive sheet, the third electrode material having the same potential as the first electrode material. Electrolyte material is
30 disposed between the first and the second electrodes and disposed between the second and the third electrodes.

In accordance with still another aspect of the present invention, a battery module stack includes

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a plurality of multi-cell battery modules stacked on top of one another. Each multi-cell battery module comprises a first electrode including a first electrode tab extending from the first electrode, a second electrode including a second electrode tab extending from the second electrode, and a third electrode including a third electrode tab extending from the third electrode. The first electrode tab, the second electrode tab, and the third electrode tab extend from the multi-cell battery module such that the first electrode tab and the third electrode tab do not contact or electrically interfere with the second electrode tab. Means are provided for electrical connection of the first and third electrode tabs of the plurality of multi-cell battery modules. Means are provided for electrical connection of the second electrode tabs of the plurality of multi-cell battery modules.

In accordance with still another aspect of the present invention, a method of making a battery module stack is disclosed. One or more first and one or more second electrodes are stacked on top of one another such that first electrode material of the first electrodes faces second electrode material of the second electrodes and such that a layer of electrolyte material on the first electrodes separates the first electrode material and the second material. The first electrodes have first tabs. The second electrodes have second tabs. The first tabs are electrically connected. The second tabs are electrically connected.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention can be further understood with reference to the following description

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in conjunction with the appended drawings, wherein like elements are provided with the same reference numerals. In the drawings:

Figure 1 is a schematic, exploded perspective view of a multi-cell battery according to an embodiment of the present invention;

Figure 2 is a schematic, side cross-sectional view of a multi-cell battery according to an embodiment of the present invention;

Figure 3 is a schematic, exploded perspective view of a group of multi-cell batteries according to an embodiment of the present invention;

Figure 4 is a schematic, side, partially cross-sectional view of a group of multi-cell batteries according to an embodiment of the present invention;

Figure 5 is a schematic, exploded perspective view of a stack of groups of multi-cell batteries according to an embodiment of the present invention;

Figure 6 is a schematic, side, partially cross-sectional view of two stacks of multi-cell batteries with electrically connected electrode tabs according to an embodiment of the present invention;

Figure 7 is a schematic, side cross-sectional view of two stacks of multi-cell batteries with electrically connected electrode tabs according to an embodiment of the present invention; and

Figure 8 is a schematic perspective view of several stacks of multi-cell batteries enclosed in an

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insulating wrapping according to an embodiment of the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENT

With reference to Figures 1 and 2, a multi-cell battery 21 includes a first electrode 31, a second electrode 41, and a third electrode 51. The first electrode 31 and the third electrode 51 are of the same potential as each other, and the second electrode 41 is of a different, or second, potential. The first electrode 31 faces a first layer of second potential electrode material 43 on the second electrode 41 to form a first electrochemical cell 22. The third electrode 51 faces a second layer of second potential electrode material 45 on the second electrode 41 to form a second electrochemical cell 23. The first and second electrochemical cells thus form a "multi-cell" battery. U.S. Patent No. 4,925,751 to Shackle et al. describes certain anode, cathode, and polymer electrolyte materials useful in forming the multi-cell battery and is incorporated by reference only to the extent that it describes such materials.

In a preferred embodiment, the multi-cell battery 21 includes two electrochemical cells 22, 23 and is referred to as a "bicell" battery. For the remainder of this description, the multi-cell battery 21 will be referred to as a bicell battery in accordance with the preferred embodiment. However, it is understood that any number of electrochemical cells 22, 23 may be stacked on top of one another in the manner described herein to form a battery 21 with any number of individual cells.

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In forming the first and third electrodes 31, 51, a layer of electrode material 33, 53 is applied in a predetermined thickness onto one surface 34, 54 of a conductive sheet 32, 52. A polymer electrolyte 35, 55 is then applied, in a layer of a predetermined thickness onto the layer of electrode material 33, 53.

The conductive sheets 32, 52 of the first and third electrodes 31, 51 are preferably formed from a web or sheet of conductive material. In a presently preferred embodiment, the conductive sheets 32, 52 are formed from a nickel or copper web or sheet. Electrode material for forming the layers of electrode material 33, 53 is applied to the web or sheet, such as by being extruded, and has a consistent, desired thickness. Polymer electrolyte material for forming the layers of electrolyte 35, 55 is applied to the electrode material, such as by being extruded, and has a consistent, desired thickness. The conductive web or sheet having layers of electrode material and electrolyte material is cut into desired shapes to form the first and third electrodes 31, 51. The electrode material 33, 53 is preferably a cathode material selected from the group of materials suited for storing ions released from an anode, with a vanadium oxide, V_6O_{13} or V_3O_8 , material being preferred.

The second electrode 41 includes a conductive sheet 42. A first layer 43 of electrode material, having a different potential to that of the layers of electrode material 33, 53 on the first and third electrodes 31, 51, is applied to a first side 44 of the conductive sheet 42. A second layer 45 of electrode material, also having a different potential to that of the layers of electrode material 33, 53 on the first

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and third electrodes 31, 51, is applied to a second side 46 of the conductive sheet 42.

As with the conductive sheets 32, 52, the conductive sheet 42 is preferably formed from a continuous conductive material, such as a nickel or copper web or sheet. The conductive sheet 42 is preferably cut in a desired shape from the web or sheet. The first and second layers of different, or second, potential electrode material 43, 45 are preferably an anode material, a lithium anode material being preferred. The first and second layers of different, or second, potential electrode material 43, 45 are deposited to a desired thickness on the web for forming the conductive sheet 42.

In forming the bicell battery 21, the first electrode 31 and the second electrode 41 are positioned relative to one another such that the first layer of different, or second, potential electrode material 43 contacts the layer of electrolyte material 35 on the first electrode 31. The third electrode 51 and the second electrode 41 are positioned relative to one another such that the second layer of different, or second, potential electrode material 45 contacts the layer of electrolyte material 55 on the third electrode 51.

Substantially all of the surface area of the second electrode 41 is within the boundaries of the surface area of the first and third electrodes 31, 51 to prevent inadvertent contact between the edge 47 of the second electrode and the edges 36, 56 of the first and third electrodes. Contact between the edge 47 of the second electrode 41 and the edges 36, 56 of the

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first and third electrodes 31, 51 might result in shorting of the bicell battery 21.

To prevent inadvertent puncturing of the layers of electrolyte material 35, 55 on the first and third electrodes 31, 51 by the edge 47 or corners 48 of the second electrode 41, which might also result in shorting of the bicell battery 21, a means 71 for masking the edge and corners of the second electrode is provided. The masking means 71 frames the edge 47 and corners 48 of the second electrode 41 while allowing contact between the substantially all of the surface area of the first and second layers of different, or second, potential electrode material 43, 45 and the electrode material 33, 53 of the first and third electrodes 31, 51, respectively. A preferred material for forming the masking means 71 is a polymeric material such as a porous polypropylene. The masking means 71 is generally quite thin, and only insignificant surface distortion of the first, second, or third electrodes 31, 41, or 51 occurs to accommodate the thickness of the masking means when the electrode surfaces contact with one another.

The first electrode 31 is provided with a conductive first electrode tab 37 extending from the first conductive sheet 32 to facilitate making an electrical connection between the first conductive sheet and an external load or power source. The first electrode tab 37 is preferably a portion of the first conductive sheet 32 that extends beyond a portion of the first conductive sheet to which electrode material 33 is applied. The second electrode 41 is provided with a second electrode tab 49 and the third electrode 51 is provided with a third electrode tab 57 in a similar manner.

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The tabs 37, 49, 57 of the first, second, and third electrodes 31, 41, 51 are preferably portions of the conductive sheets 32, 42, 52 that are not coated with electrode material 33, 53 or different, or second, potential electrode material 43, 45. As seen in Figures 3, 4, 5, and 7, the first electrode tab 37 and the third electrode tab 57 preferably extend from the first electrode 31 and the third electrode 51 such that, when the first electrode and the third electrode are positioned around the second electrode 41 to form a bicell battery 21, the first electrode tab and the third electrode tab are aligned substantially adjacent to one another over the height of the bicell battery. As seen in Figures 4 and 7, the aligned first electrode tab 37 and third electrode tab 57 are electrically connected to one another by being bent to contact one another. As seen in Figure 6, the aligned second electrode tabs 49 are electrically connected to one another by being bent to contact one another.

As seen in Figures 3 and 4, a desired number of bicell batteries 21 are stacked, one on top of another, to form a group 25 of bicell batteries. As seen in Figures 3 and 5, the second electrode tabs 49 extend from the second electrodes 41 such that, when the first electrodes and the third electrodes 51 are positioned around the second electrodes to form bicell batteries 21, the second electrode tabs are offset from and do not contact or otherwise electrically interfere with the first or third electrode tabs 37, 57. The second electrode tabs 49 of each of the second electrodes 41 are aligned relative to one another over the height of the battery along a single line offset from a line extending through the first and third electrode tabs 37, 57. The aligned second electrode tabs 49 are electrically connected by being bent to

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contact one another. When the plurality of bicell batteries 21 are stacked on top of one another, the non-coated side 59 of the third conductive sheet 52 of the third electrode 51 contacts with, and is thereby electrically connected to, the non-coated side 39 of the first conductive sheet 32 of a subsequent first electrode 31.

As noted above, in order for the second electrode tabs 49 of the plurality of bicell batteries 21 to contact one another, and in order for the first electrode tabs 37 and the third electrode tabs 57 of the plurality of bicell batteries to contact one another, because of the thickness of the various layers of material, some of the first electrode tabs, the second electrode tabs, and the third electrode tabs are bent to contact other tabs. As seen, for example, in Figure 4, in a group 25 of bicell batteries 21, certain first and third electrode tabs 37, 57, generally on the outside of the group, are bent more than others. Similarly, as seen in Figure 6, certain second electrode tabs 49, generally on the outside of the group 25, are bent more than others in endeavoring to electrically connect the second electrode tabs to one another.

Because the anode and cathode materials applied to the conductive sheets 32, 42, and 52 may tend, under some conditions, to de-laminate from the conductive sheets, and because of the possibility of breakage of electrode tabs 37, 49, 57, it is desirable to minimize the degree to which the electrode tabs are bent. Minimizing bending of the tabs 37, 49, 57 minimizes the danger of breakage of electrode tabs. To minimize the need to bend tabs 37, 49, 57, a group 25 preferably includes only approximately six or seven

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bicell batteries 21 so that the tabs in one group may be electrically connected to one another, and the bicell batteries are aligned with one another, in such a manner that no tab need be excessively bent to
5 contact another tab in the group. By maintaining the number of bicell batteries 21 in a group 25 at approximately six or seven, it is not generally necessary to excessively bend any individual electrode tab 37, 49, 57 to electrically connect the tab with the
10 other tabs in the group.

In addition to maintaining the size of a group 25 to a reasonable number of bicell batteries 21, conductive spacer means 100, seen in Figure 5, are provided for aligning and electrically connecting the
15 plurality of second electrode tabs 49 and for aligning and electrically connecting the plurality of first electrode tabs 37 and third electrode tabs 57 of one or more groups of bicell batteries in such a manner as to minimize any bending of the tabs 37, 49, 57. The
20 spacer means 100 includes means for aligning and electrically connecting a desired number of first electrode tabs 37 and third electrode tabs 57, preferably an electrode spacer bar assembly 101, and means for aligning and electrically connecting a
25 desired number of second electrode tabs 49 of groups 25 of bicell batteries 21, preferably a different, or second, potential electrode spacer bar assembly 111.

As seen in Figures 4 and 7, bending of the first electrode tabs 37 and the third electrode tabs 57
30 of a group 25 of bicell batteries 21 is minimized and the tabs are electrically connected to one another by being clamped together in the electrode spacer bar assembly 101. As seen in Figures 5 and 7, the electrode spacer bar assembly 101 includes a desired

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number of electrode spacers 102, an electrode terminal 103 for electrically connecting the electrode spacer bar assembly to an outside load or power source, a pair of electrode spacer bar assembly end plates 104, and a fastening means such as shafts 105 with increased diameter caps or ends 105' for holding the electrode spacer bar assembly together. The ends 105' may be part of the shaft 105 or separate elements secured thereto. For example, the shaft 105 may be a rivet that is deformed to form each of the ends 105', or the shaft may be provided with any other suitable, separate fastening means, such as a bolt and nut arrangement, or other suitable fastener. The electrode spacer bar assembly end plates 104 sandwich the electrode spacers 102 and the electrode terminal 103 when the shaft 105 with ends 105' fastens the electrode spacer bar assembly 101 together around the tabs 37, 57.

As seen in Figures 4, 5, and 7, the first electrode tabs 37 and the third electrode tabs 57 of each group 25 of bicell batteries 21 are clamped between either two electrode spacers 102, an electrode spacer and an electrode terminal 103, an electrode spacer and an electrode spacer bar assembly end plate 104, or an electrode terminal and an electrode spacer bar assembly end plate. The electrode spacers 102, the electrode terminal 103, and the electrode spacer bar assembly end plates 104, as well as the first and third electrode tabs 37, 57 of groups 25 of bicell batteries 21, are fastened together by the shaft 105, seen in Figures 5 and 7, and its ends 105'. The thicknesses of individual ones of the electrode spacer bars 102, electrode terminals 103, and electrode spacer bar assembly end plates 104, and the number of bicell batteries 21 constituting a group 25, are preferably selected such that any bending of the first electrode

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tabs 37 or third electrode tabs 57 for being clamped by the electrode spacer bar assembly 101 presents little danger of delamination of electrode material 33, 53 or of breakage of electrode tabs.

5 As seen in Figures 5 and 6, a different, or second, potential electrode spacer bar assembly 111, including different, or second, potential electrode spacers 112 and a different, or second, potential electrode terminal 113 fastened between two different,
10 or second, potential electrode spacer bar assembly end plates 114 by fastening means such as shafts 115 with increased diameter caps or ends 115', seen in Figure 5, is provided for electrically connecting the second electrode tabs 49 of groups 25 of bicell batteries 21
15 in the same or a similar fashion as the electrode spacer bar assembly 101 electrically connects the first and third electrode tabs 37, 57. As noted above, the second electrode tabs 49 are offset from and do not contact or otherwise electrically interfere with the
20 first and third electrode tabs 37, 57. The electrode spacer bar assembly 101 is also offset from and does not contact or otherwise electrically interfere with the second electrode tabs 49. Similarly, the different, or second, potential electrode spacer bar
25 assembly 111 is offset from and does not contact or otherwise electrically interfere with the first and third electrode tabs 37, 57 or the electrode spacer bar assembly 101.

Similar to the elements of the electrode
30 spacer bar assembly 101, the thickness of individual ones of the different, or second, potential electrode spacer bars 112, different, or second, potential electrode terminals 113, and different, or second, potential electrode spacer bar assembly end plates 114,

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and the number of bicell batteries 21 constituting a group 25, are preferably selected such that any bending of the second electrode tabs 49 for being clamped by the different, or second, potential electrode spacer bar assembly 111 presents little danger of delamination of different, or second, potential electrode material 43, 45 or breakage of second electrode tabs 49. In a preferred embodiment, the same number of electrode spacer bars 102 are used as the number of different, or second, potential electrode spacer bars 112. However, if desired, different numbers of electrode spacer bars 102 than different, or second, potential electrode spacer bars 112 may be used, and different numbers of second electrode tabs 49 may be clamped between different, or second, potential electrode spacer bars, different, or second, potential electrode terminals 113, and different, or second, potential electrode spacer bar assembly end plates 114 than first and third electrodes that are clamped between corresponding members of the electrode spacer bar assembly 101.

In addition to clamping together the first and third electrode tabs 37, 57 of groups of bicell batteries and clamping together the second electrode tabs 49 of groups 25 of bicell batteries, the electrode spacer bar assembly 101 and the different, or second, potential electrode spacer bar assembly 111 facilitate proper alignment of the tabs. Considering, first, the alignment of the first and third electrode tabs 37, 57, as seen in Figures 1 and 3, the first electrode tabs are preferably formed with holes 38 and the third electrode tabs are preferably formed with holes 58. The holes 38 and 58 of a plurality of bicell batteries 21 are aligned relative to one another by being stacked on top of one another over the shafts 105. Similarly, as seen in Figure 5, the electrode spacer bars 102 are

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preferably formed with holes 106, the electrode terminal is preferably formed with holes 107, and the electrode spacer bar assembly end plates 104 are preferably formed with holes 108 to facilitate being aligned relative to one another, as well as to the first and third electrode tabs 37, 57, by being stacked over the shafts 105.

Similarly, as seen in Figures 1 and 3, the second electrode tabs 49 are preferably formed with holes 50. The holes 50 of a plurality of bicell batteries 21 are aligned relative to one another by being stacked on top of one another over the shafts 115. As seen in Figure 5, the different, or second, potential electrode spacer bars 112 are preferably formed with holes 116, the different, or second, potential electrode terminal 113 is preferably formed with holes 117, and the different, or second, potential electrode spacer bar end plates 114 are preferably formed with holes 118 to facilitate being aligned relative to one another, as well as to the second electrode tabs 49, by being stacked over the shafts 115. The electrode terminal 103 is preferably formed with additional holes 109 and the different, or second, potential electrode terminal 113 is preferably formed with additional holes 119 to facilitate making external connections with power sources or loads.

The thickness of the electrode spacer bar assembly 101 plus the thickness of a plurality of clamped first electrode tabs 37 and third electrode tabs 57 of a plurality of bicell batteries 21 is preferably substantially the same as the thickness of the bicell batteries. Similarly, the thickness of the different, or second, potential electrode spacer bar assembly 111 plus the thickness of a plurality of

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clamped second electrode tabs 49 of the plurality
bicell batteries 21 is preferably substantially the
same as the thickness of the plurality of bicell
batteries. It is preferred to form the electrode
5 spacer bar assembly 101 and the different, or second,
potential electrode spacer bar assembly 111 in such
thicknesses so that a stack 26 of groups 25 of a
plurality of bicell batteries 21 and the spacer means
100 is a substantially constant thickness.

10 The stack 26 of bicell batteries 21 may be
assembled by inserting fastening means such as shafts
105 through holes 108 in an electrode spacer bar
assembly end plate 104 and inserting fastening means
such as shafts 115 through holes 118 in a different, or
15 second, potential electrode spacer bar assembly end
plate 114. First electrodes 31, second electrodes 41,
and third electrodes 51 are then layered on top of one
another, the shafts 105 are inserted through the holes
38, 58, and the shafts 115 are inserted through the
20 holes 50 until a desired number of bicell batteries 21
form a group 25. If desired, the masking means 71 may
be provided between the first electrode 31 and the
second electrode 41 and between the second electrode
and the third electrode 51.

25 The shafts 105 are then inserted through the
holes 106 of an electrode spacer bar 102 so that the
electrode spacer bar and the electrode spacer bar
assembly end plate 104 sandwich the first electrode
tabs 37 and the third electrode tabs 57 of the group 25
30 of bicell batteries 21. The shafts 115 are inserted
through the holes 116 of a different, or second,
potential electrode spacer bar 112 so that the
different, or second, potential electrode spacer bar
and the different, or second, potential spacer bar

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assembly end plate 114 sandwich the second electrode tabs 49 of the group 25 of bicell batteries 21. Additional groups 25 of bicell batteries 21 of the same or varying numbers of bicell batteries and additional
5 spacer bars 102, 112 may be attached to the shafts 105, 115 in the same fashion.

The shafts 105, 115 are inserted through holes 107, 117, respectively, of the electrode terminal 103 and the different, or second, potential electrode
10 terminal 113. Normally, the electrode terminal 103 and the different, or second, potential electrode terminal 113 are applied to the assembly so that they project from a center of the stack 26 of bicell batteries 21. After a desired number of groups 25 of bicell batteries
15 21, spacer bars 102, 112, and terminals 103, 113 are connected, the shafts 105 are inserted through the holes 108 in another electrode spacer bar assembly end plate 104, the shafts 115 are inserted through the holes 118 in another different, or second, potential
20 electrode spacer bar assembly end plate 114. The shafts 105, 115 are secured to the stacks 26 by the ends 105', 115' and fasten together the electrode spacer bar assembly 101, the first electrodes 31, and the third electrodes 51 and fasten together the
25 different, or second, potential electrode spacer bar assembly 111 and the second electrodes 41 such as by deforming the shafts to form increased diameter ends or by attaching nuts or caps to threaded portions of the shafts to form ends.

30 As shown in Figures 6-8, more than one stack 26 may be electrically connected to form a multi-stack battery 10 having more power than a single stack. Multiple stacks 26 are stacked on top of one another to such that an electrode spacer bar assembly endplate 104

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of a first stack contacts an electrode spacer bar assembly endplate of a subsequent stack and a different, or second, potential electrode spacer bar assembly endplate 114 of the first stack contacts a
5 different, or second, potential electrode spacer bar assembly endplate 114 of the subsequent stack, thereby electrically connecting the stacks. Wiring or other suitable means for electrically connecting the terminals 103, 113 of multiple stacks 26 of bicell
10 batteries 21 may also be provided to electrically connect the stacks.

As seen in Figures 6, 7, and 8, after a stack 26 of bicell batteries 21, or a multi-stack battery 10, has been formed as described above, a means 120 for
15 enclosing the stack is provided around the stack. Preferably, the enclosing means 120 includes a non-conductive, heat-sealable plastic wrap material that is wrapped around the stack 26 and is heat-sealed around the stack such that the stack is insulated. The
20 enclosing means 120 may also be used to secure the various components of the stack 26 together. At least a portion of an electrode terminal 103 and a portion of a different, or second, potential electrode terminal 113 extend out of the enclosing means 120 (which is
25 sealed at its edges). Alternatively, conductive means such as wiring (not shown) for electrically connecting the terminals 103, 113 extends from the enclosing means 120, and the terminals 103, 113 are sealed inside the enclosing means. Sealing means 125, such as a hot-melt
30 adhesive, is applied around edges 121 of the wrapped material around the electrode terminals 103 and the different, or second, potential electrode terminals 113, or conductive means (not shown) connecting those terminals, to ensure that the stack 26 is well sealed.

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The stack 26 is manufactured by a method wherein the first electrode 31, the second electrode 41, and the third electrode 51 are stacked on top of one another such that the electrode material 33, 53 of
5 the first and third electrodes faces the different, or second, potential electrode material 43, 45 on the second electrode. The first electrode 31, the second electrode 41, and the third electrode 51 are stacked such that the electrolyte material layer 35 on the
10 first electrode separates the electrode material layer 33 on the first electrode and the layer of different, or second, potential electrode material 43 on the first surface 44 of the conductive sheet 42 and such that the electrolyte material layer 55 on the third electrode
15 separates the electrode material layer 53 on the third electrode and the layer of different, or second, potential electrode material 45 on the second surface 46 of the conductive sheet. The first electrode tabs 31 and the third electrode tabs 57 are electrically
20 connected to one another by the electrode spacer bar assembly 101. The second electrode tabs 49 are electrically connected to one another by the different, or second, potential electrode spacer bar assembly 111.

The first and third electrode tabs 37, 57 are
25 clamped between sets of electrode spacer bars 102, electrode terminals 103, or electrode spacer bar assembly endplates 104, and the second electrode tabs 49 are clamped between sets of different, or second, potential electrode spacer bars 112, different, or
30 second, potential electrode terminals 113, or different, or second, potential electrode spacer bar assembly endplates 114. Preferably, the first and third electrode tabs 37, 57 are fastened in position relative to the electrode spacers 102, the electrode
35 terminal 103, and the electrode spacer bar assembly end

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plates 104 with shafts 105 having ends 105'; and, preferably, the second electrode tabs 49 are fastened in position relative to the different, or second, potential electrode spacers 112, the different, or second, potential electrode terminals 113, and the different, or second, potential electrode spacer bar assembly end plates 114 with shafts 115 having ends 115'. Holes 38, 58, 106, 107, and 108 are preferably formed in, respectively, the first electrode tabs 37, the third electrode tabs 57, the electrode spacer bars 102, the electrode terminal 103, and the electrode spacer bar assembly end plates 104, and holes 50, 116, 117, and 118 are preferably formed in, respectively, the second electrode tabs 49, the different, or second, potential electrode spacer bar 112, the different, or second, potential electrode terminal 113, and the different, or second, potential electrode spacer bar assembly end plates 114 before fastening with shafts 105, 115.

The various components of the stack 26 with the above-noted holes may be stacked on top of another in such a manner that the shafts 105, 115 act as a guide for properly aligning the components. Alternatively, the shafts 105, 115 fasten together components that have been pre-aligned, such as by stacking the components in a form of a shape corresponding to the shape of the components, and form the above-noted holes while the fastening is taking place.

The bicell batteries 21 have thus far been described with reference to first and third electrodes 31, 51 including polymer electrolyte layers 35, 55 on electrode material layers 33, 53. It is, however, possible to form polymer electrolyte layers on the

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different, or second, potential electrode material layers 43, 45 on the different, or second, potential electrode 41, instead of on the electrode material layers 33, 53.

5 The bicell batteries 21 have also, thus far, been described with reference to first and third electrodes 31, 51 being larger in surface area than a second electrode 41, such that substantially all of the surface area of the second electrode is bound by the
10 first and third electrodes. It is, however, possible to form second electrodes 41 that are larger in surface area than first and third electrodes 31, 51, such that substantially all of the surface area of the first and third electrodes is bounded by the second electrodes.
15 Similarly, masking means 71 may be provided around the edges of the first and third electrodes 31, 51 to avoid contact of the electrode material 33, 53 with the different, or second, potential electrode material 43, 45.

20 Further, the bicell batteries 21 have been described, thus far, with reference to first and third electrode tabs 37, 57 that are aligned with each other such that they are clamped together in an electrode spacer bar assembly 101. It is also possible to form
25 first and third electrode tabs 37, 57 that do not align with one another in a bicell battery 21. One electrode spacer bar assembly may be provided for clamping and electrically connecting all of the first electrode tabs 37 and another electrode spacer bar assembly may be
30 provided for clamping and electrically connecting all of the third electrode tabs 57. The two electrode spacer bar assemblies may then be electrically connected to one another.

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The foregoing has described the principles, preferred embodiments and modes of operation of the present invention. However, the invention should not be construed as limited to the particular embodiments
5 discussed. Instead, the above-described embodiments should be regarded as illustrative rather than restrictive, and it should be appreciated that variations may be made in those embodiments by workers skilled in the art without departing from the scope of
10 present invention as defined by the following claims.

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WHAT IS CLAIMED IS:

1. An electrochemical cell, comprising:
a first electrode, the first electrode
including means for first electrode current collection,
5 the first electrode current collection means being
formed from a first conductive sheet, and a layer of
first electrode material;
a second electrode having a different
potential than that of the first electrode, the second
10 electrode including means for second electrode current
collection, the second electrode current collection
means being formed from a second conductive sheet, and
a layer of second electrode material;
an electrolyte coated on one of the
15 first or second electrode materials and contacting with
the other of the first or second electrode materials;
and
an outer periphery of the first
electrode being larger than an outer periphery of the
20 second electrode such that substantially all of the
outer periphery of the second electrode is bounded by
the outer periphery of the first electrode.
2. The electrochemical cell of claim 1,
further comprising a means for masking at least a
25 portion of the outer periphery of the second electrode.
3. The electrochemical cell of claim 1,
further comprising a first electrode tab extending from
the first conductive sheet.
- 30 4. The electrochemical cell of claim 3,
wherein first electrode material contacts the electrode
tab and electrolyte is coated on the first electrode
material on the electrode tab.

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5. The electrochemical cell of claim 3, further comprising a second electrode tab extending from the second conductive sheet, the second electrode tab and the first electrode tab extending from the electrochemical cell and out of contact with one another.

6. A multi-cell battery module, comprising:
a first electrode, the first electrode including means for first electrode current collection, the first electrode current collection means being formed from a first conductive sheet, and a layer of first electrode material contacting a surface of the first conductive sheet;

a second electrode, the second electrode including means for second electrode current collection, the second electrode current collection means being formed from a second conductive sheet, and first and second layers of second electrode material contacting first and second surfaces of the second conductive sheet, the second electrode material having a different potential than that of the first electrode material;

a third electrode, the third electrode including means for third electrode current collection, the third electrode current collection means being formed from a third conductive sheet, and a layer of third electrode material contacting a surface of the third conductive sheet, the third electrode material having the same polarity as the first electrode material; and

electrolyte material disposed between the first and the second electrodes and disposed between the second and the third electrodes.

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7. The multi-cell battery module of claim 6, wherein the electrolyte material is coated on the layers of first and third electrode material.

5 8. The multi-cell battery module of claim 6, wherein the electrolyte material is coated on the first and second layers of second electrode material.

9. The multi-cell battery module of claim 6, wherein the first electrode further includes a first electrode tab extending from the first conductive
10 sheet, the third electrode further includes a third electrode tab extending from the third conductive sheet, the second electrode further includes a second electrode tab extending from the second conductive sheet, the first electrode tab, the third electrode
15 tab, and the second electrode tab extend from the multi-cell battery module such that the first electrode tab and the third electrode tab do not contact the second electrode tab.

10. The multi-cell battery module of claim
20 9, wherein the first electrode tab and the third electrode tab contact one another.

11. A battery module stack, comprising:
a plurality of multi-cell battery
modules stacked on top of one another, each multi-cell
25 battery module comprising:

a first electrode including a
first electrode tab extending from the first
electrode;
a second electrode including a
30 second electrode tab extending from the
second electrode;

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a third electrode including a third electrode tab extending from the third electrode;

5 the first electrode tab, the second electrode tab, and the third electrode tab extend from the multi-cell battery module such that the first electrode tab and the third electrode tab do not contact or electrically interfere with the second
10 electrode tab, and the first and third electrode are the same potential and the second electrode is of a different potential than the first and third electrodes;

means for electrical connection of the
15 first and third electrode tabs of the plurality of multi-cell battery modules; and

means for electrical connection of the second electrode tabs of the plurality of multi-cell battery modules.

20 12. The battery module stack of claim 11, the first electrode further including means for first electrode current collection, the first electrode current collection means being formed from a first conductive sheet, and a layer of first electrode
25 material contacting a surface of the first conductive sheet, and the first electrode tab extends from the first conductive sheet;

the second electrode further including means for second electrode current collection, the
30 second electrode current collection means being formed from a second conductive sheet, and first and second layers of second electrode material contacting first and second surfaces of the second conductive sheet, and the second electrode tab extends from the second
35 conductive sheet;

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the third electrode further including means for third electrode current collection, the third electrode current collection means being formed from a third conductive sheet, and a layer of third electrode material contacting a surface of the third conductive sheet, and the third electrode tab extends from the third conductive sheet;

a first layer of electrolyte material is disposed between the first electrode material and the first layer of second electrode material; and

a second layer of electrolyte material is disposed between the third electrode material and the second layer of second electrode material.

13. The battery module stack of claim 12, wherein the first and second layers of electrolyte material are coated on the first and third electrode materials.

14. The battery module stack of claim 12, wherein the first and second layers of electrolyte material are coated on the first and second layers of second electrode material.

15. The battery module stack of claim 11, wherein the means for electrical connection of the first and third electrode tabs includes means for clamping together one or more first and one or more third electrode tabs.

16. The battery module stack of claim 15, wherein the clamping means includes one or more spacer bars.

17. The battery module stack of claim 16, wherein spacer bars and groups of first and third

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electrode tabs of a predetermined number of the plurality of multi-cell battery modules are arranged such that a first group of first and third electrode tabs is clamped between a first and a second spacer bar, and a second group of first and third electrode tabs, adjacent to the first group, is clamped between the second and a third spacer bar.

18. The battery module stack of claim 11, wherein the sum of the thicknesses of the means for electrical connection of the first and third electrode tabs and the first and the third electrodes is substantially the same as the thickness of the plurality of multi-cell battery modules.

19. The battery module stack of claim 11, wherein the means for electrically connecting the second electrode tabs includes means for clamping together two or more second electrode tabs.

20. The battery module stack of claim 19, wherein the clamping means includes one or more second electrode spacer bars.

21. The battery module stack of claim 20, wherein second electrode spacer bars and groups of second electrode tabs of a predetermined number of the plurality of multi-cell battery modules are arranged such that a first group of second electrode tabs is clamped between a first and a second electrode spacer bar, and a second group of second electrode tabs, adjacent to the first group, is clamped between the second and a third second electrode spacer bar.

22. The battery module stack of claim 11, wherein the sum of the thicknesses of the means for

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electrical connection of the second electrode tabs and the second electrode tabs is substantially the same as the thickness of the plurality of multi-cell battery modules.

5 23. The battery module stack of claim 11, further comprising means for enclosing the plurality of multi-cell battery modules such that at least a portion of the means for electrically connecting the first and third electrode tabs of the plurality of multi-cell
10 battery modules and at least a portion of the means for electrically connecting the second electrode tabs of the plurality of multi-cell battery modules extend outwardly from the enclosing means.

 24. The battery module stack of claim 23,
15 wherein the enclosing means include a stretch-wrap material wrapped around the plurality of multi-cell battery modules such that at least a portion of the means for electrically connecting the first and third electrode tabs of the plurality of multi-cell battery
20 modules and at least a portion of the means for electrically connecting the second electrode tabs of the plurality of multi-cell battery modules extend from the stretch-wrap material.

 25. The battery module stack of claim 24,
25 wherein the stretch-wrap material is sealed around the portion of the means for electrically connecting the first and third electrode tabs and the portion of the means for electrically connecting the second electrode tabs by an adhesive material.

30 26. A method of making a battery module stack, comprising the steps of:

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stacking one or more first and one or more second electrodes on top of one another such that first electrode material of the first electrodes faces second electrode material of the second electrodes and such that a layer of electrolyte material on the first electrodes separates the first electrode material and the second electrode material, the first electrodes having first tabs, and the second electrodes having second tabs;

electrically connecting the first tabs;

and

electrically connecting the second tabs.

27. The method of making a battery module stack of claim 26, wherein the first tabs are electrically connected by being clamped together by a first clamping means, and the second tabs are electrically connected by being clamped together by a second clamping means.

28. The method of making a battery module stack of claim 26, wherein the first tabs are electrically connected by being fastened together between a first and a second spacer, and the second tabs are electrically connected by being fastened together between a third and a fourth spacer.

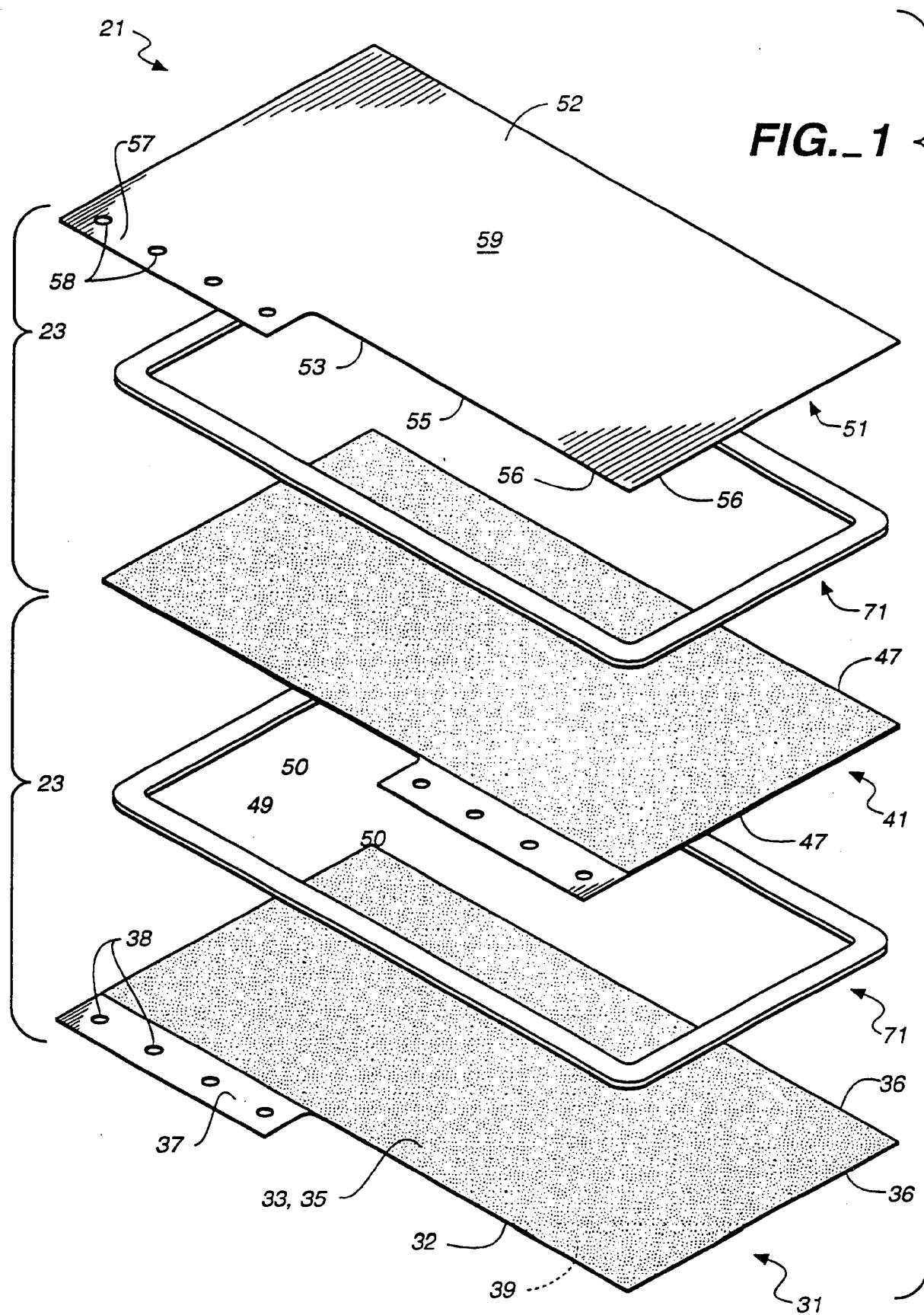
29. The method of making a battery module stack of claim 28, comprising the further step of forming fastener holes in the first tabs, the second tabs, and the first, second, third, and fourth spacers prior to fastening together the first tabs between the first and second spacers and prior to fastening together the second tabs between the third and fourth spacers, wherein the first tabs are fastened between the first and second spacers by a first fastener that

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is passed through the holes in the first tabs and the first and second spacers, and the second tabs are fastened between the third and fourth spacers by a second fastener that is passed through the holes in the
5 second tabs and the third and fourth spacers.

30. The method of making a battery module stack of claim 26, comprising the further step of enclosing the first and the second electrodes together in an enclosing means.

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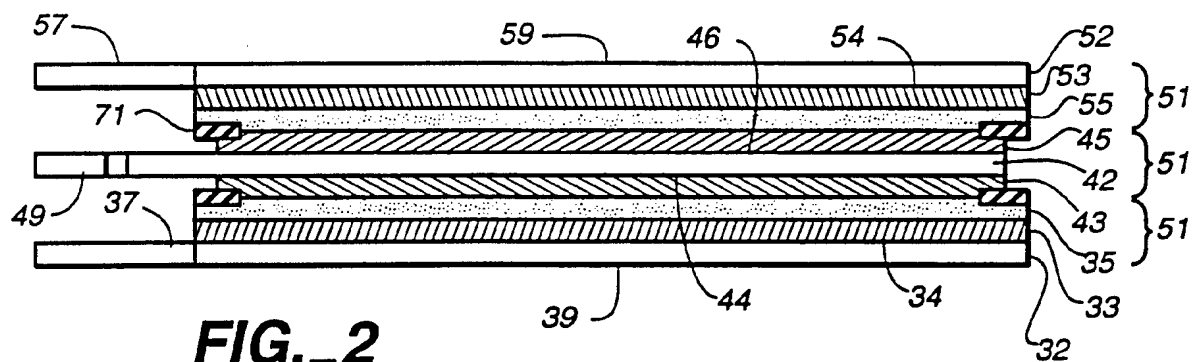


FIG. 2

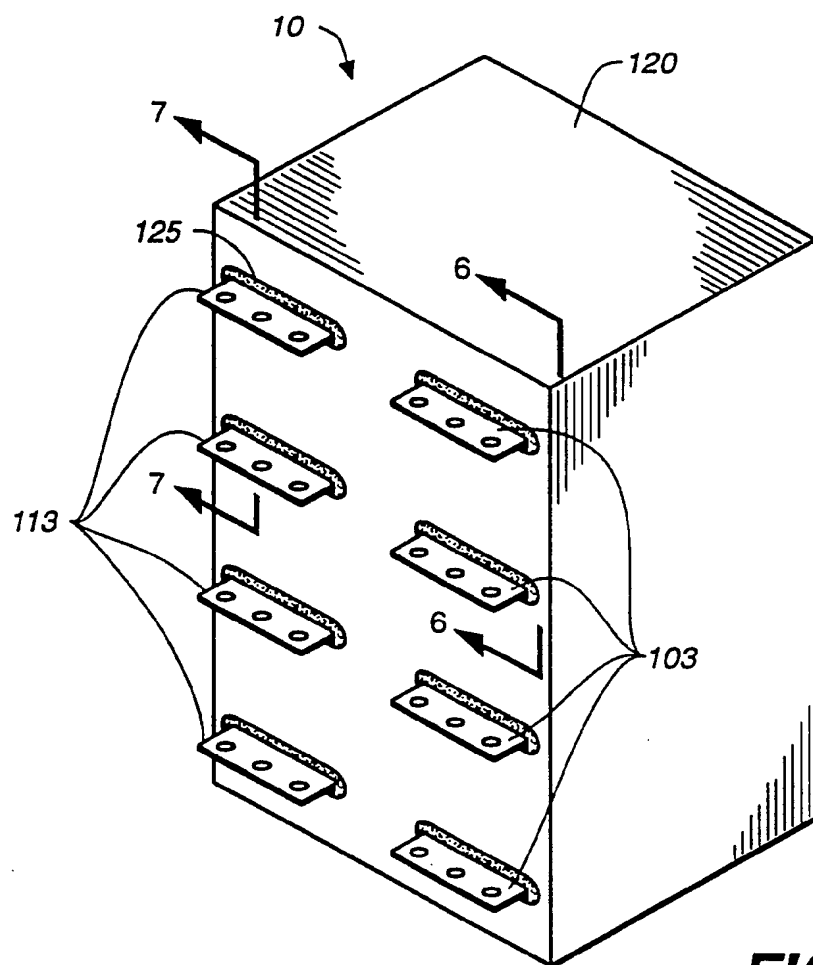


FIG._8

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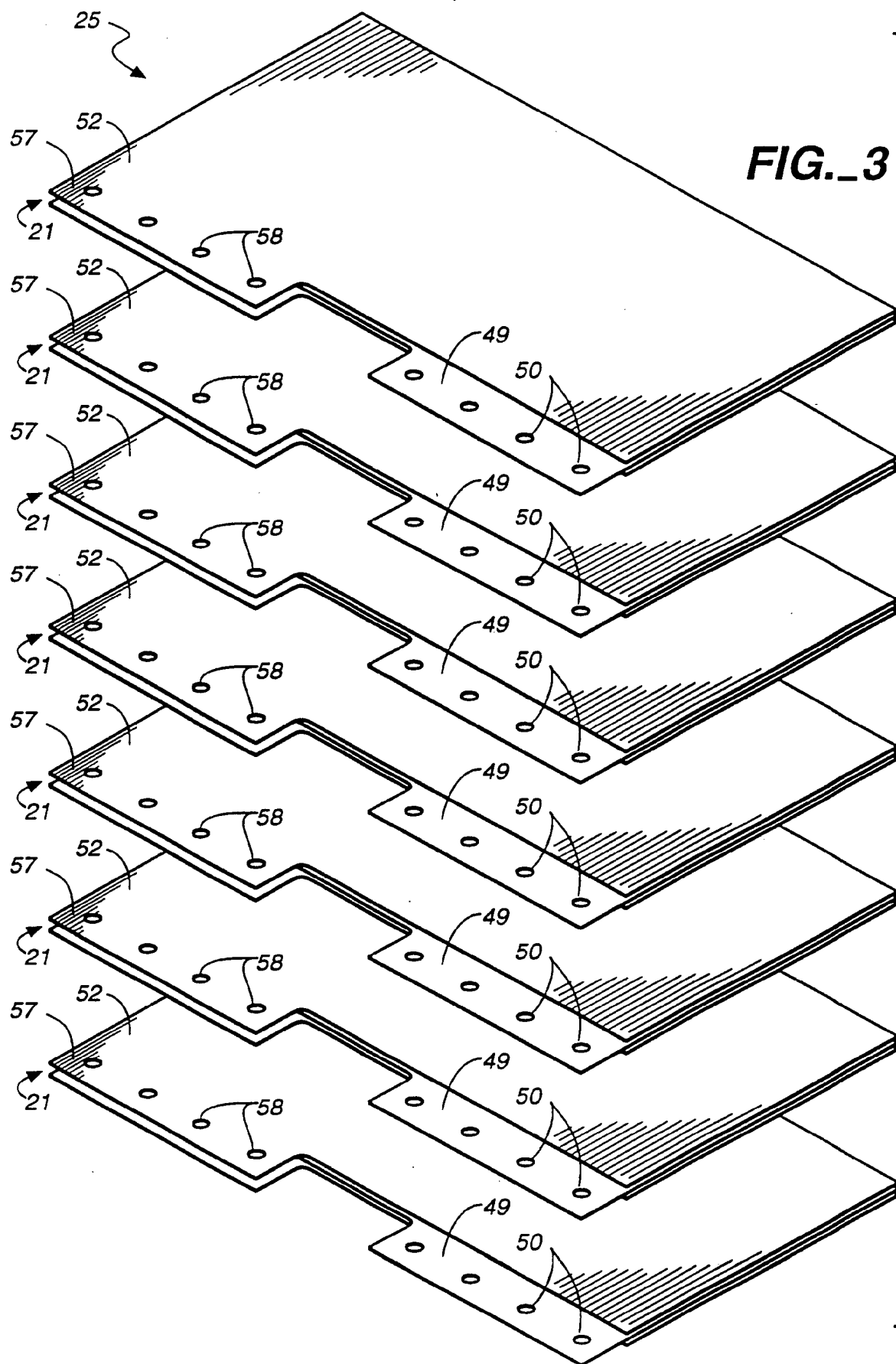
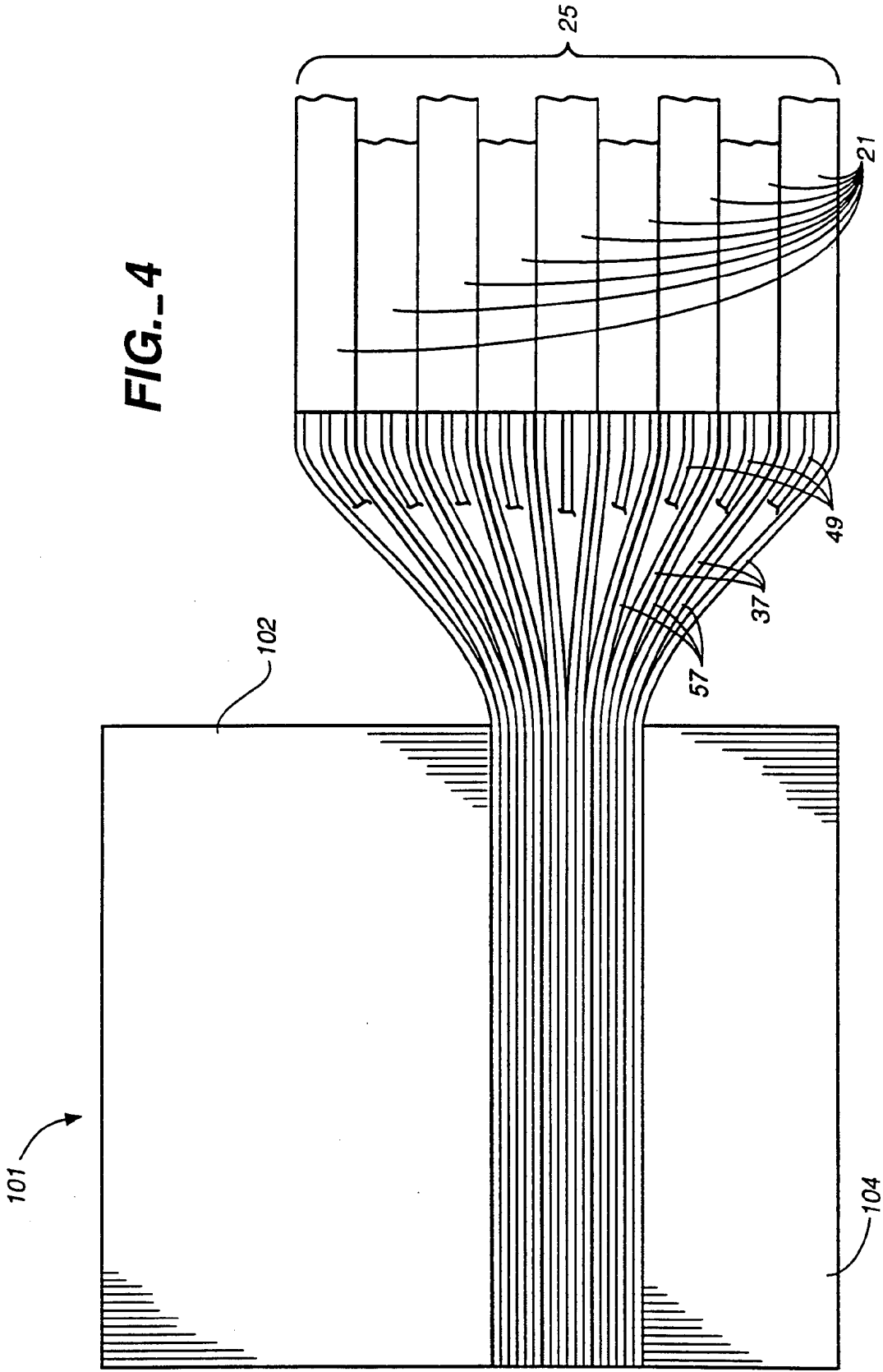
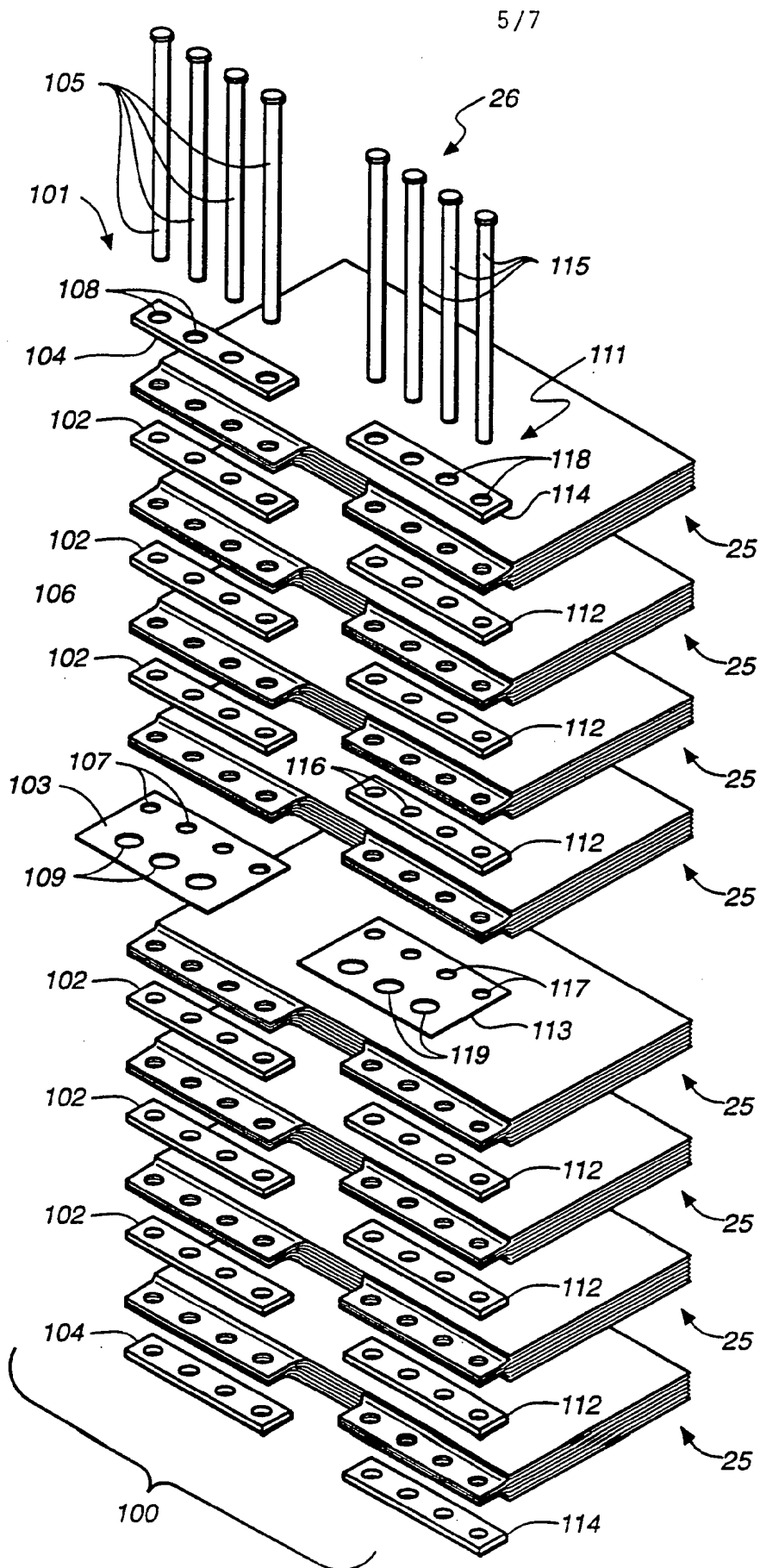


FIG. 4





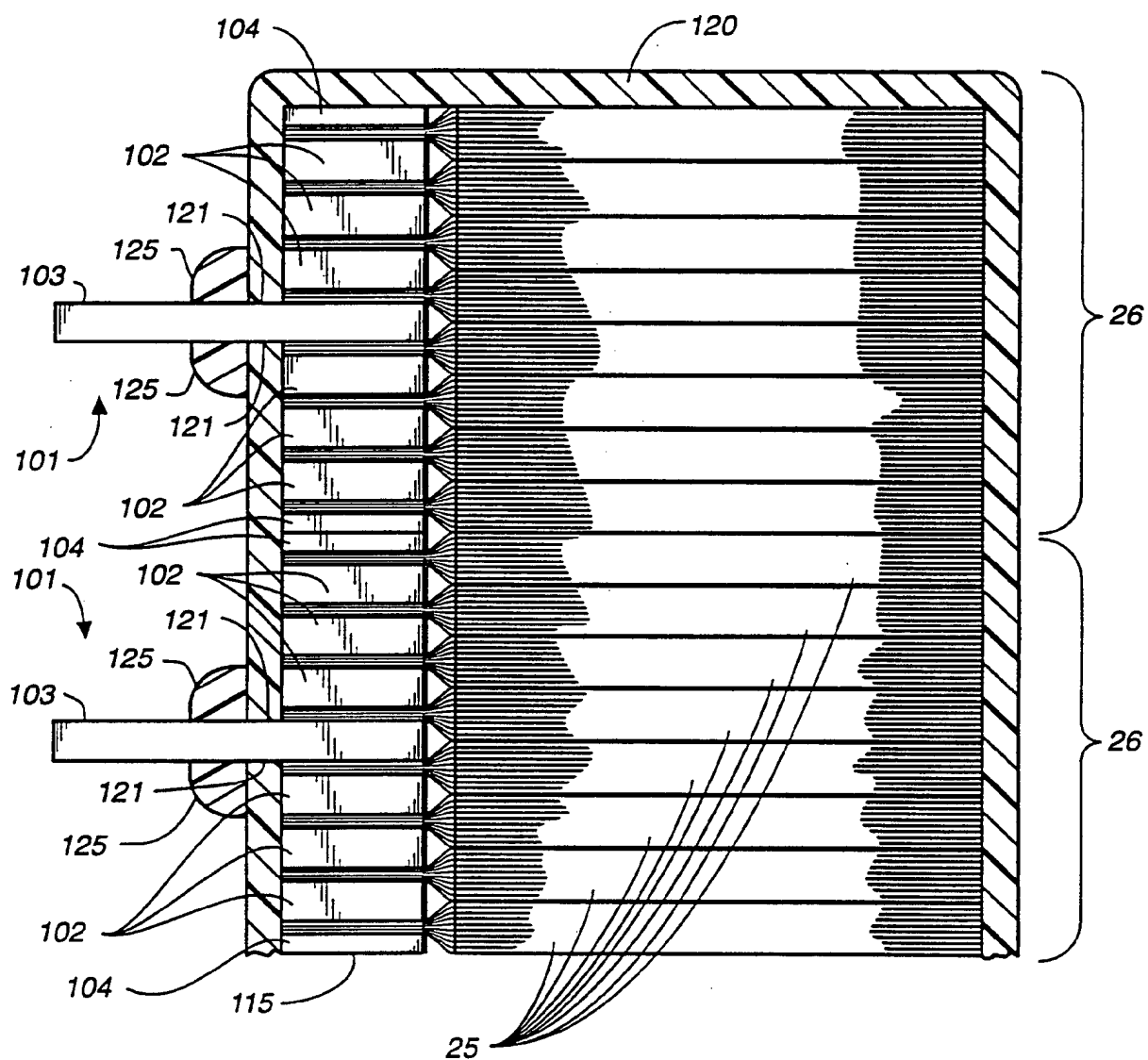
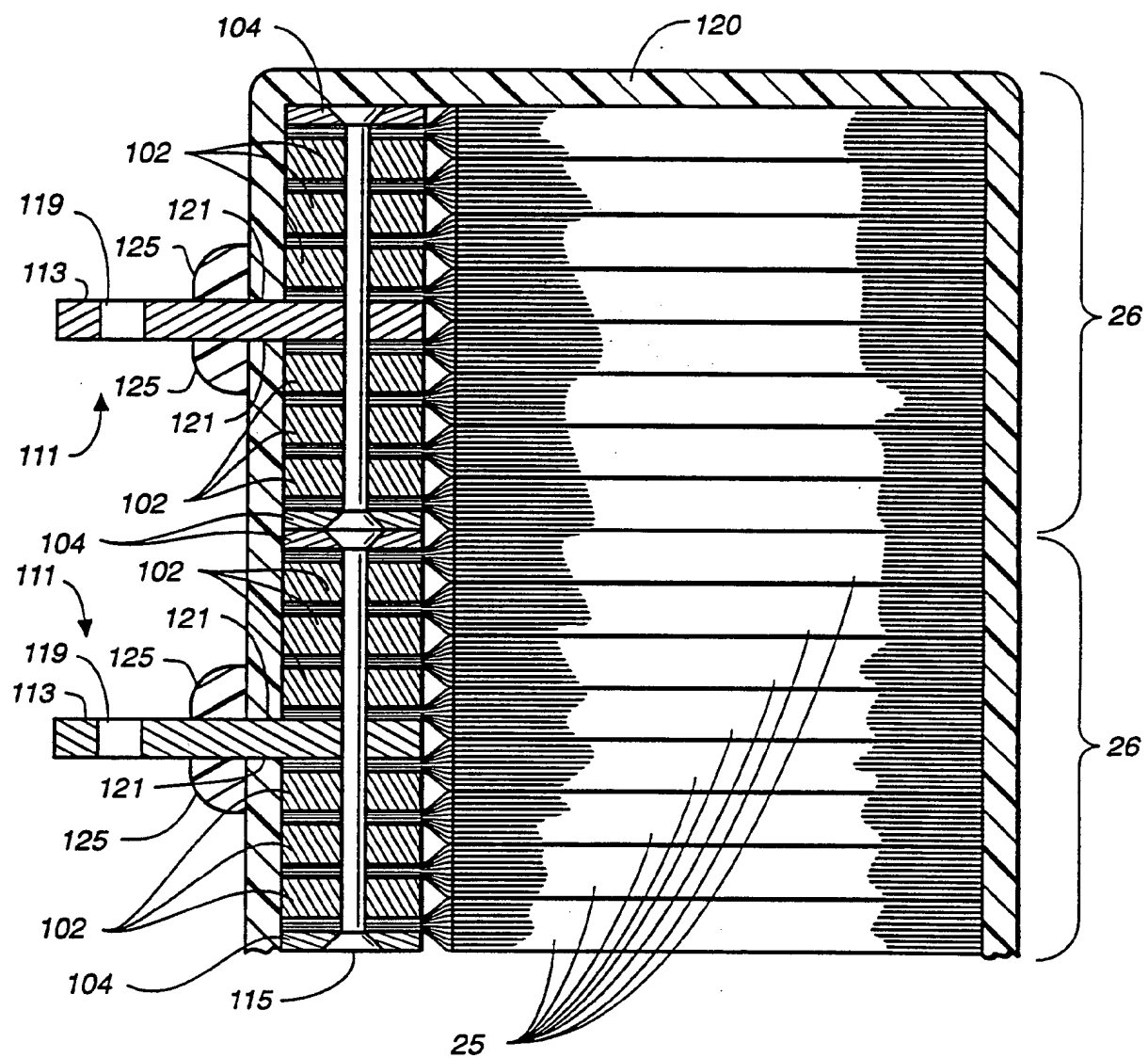


FIG. 6

**FIG. 7**

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 93/10346

A. CLASSIFICATION OF SUBJECT MATTER
IPC 5 H01M2/26 H01M6/46

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 5 H01M

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	GB,A,1 209 336 (SOC. LES PILES WONDER) 21 October 1970 see claims 1-9 ---	1-30
A	EP,A,0 199 476 (LUCAS INDUSTRIES PUBLIC LTD. CO.) 29 October 1986 see claims 1-12; figure 1 ---	1-30
A	US,A,3 201 279 (J.J. ROOT) 17 August 1965 see claims 1-14 ---	1-30
A	US,A,3 005 864 (D.T. SHARPE) 24 October 1961 see claims 1-9; figures 1,2 -----	1-30

☐ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

1 March 1994

Date of mailing of the international search report

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/US 93/10346

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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